

Work Order ID 160879

Friday, May 05, 2017 9:09:07 AM

160879

Page 1

Item ID: PB67-43001-03 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Aft Blade Fold Assembly
 Start Date: 6/2/2017 Start Qty: 1.00 ***1*** **2** **DAS**
 Required Date: 7/17/2017 Req'd Qty: 1.00 ***1*** **21**
 Reference: SCHEDULED/U **9-89** Cust Item ID:
 Customer:

Approvals: Process Plan: **DAS** Date: **MAY 05 2017** Tooling: Date: Run Start ***NR1***
 QC: **21** Date: SPC (Y/N): Date: Stop ***NR2***
9-89

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
B67-43001-03	D

100 0.00
100 Small Fab
 Small Fab Memo 2.20
 Small Fab 1- Assemble as per dwg and use 242 threadlock A/R shown on dwg PB67-43001 page 2.
 A/R 242 THREADLOCK batch: **133046**
 A/R touch up paint with sandflex green batch: **126701**

110 0.00
110 QC Memo 0.02
 Quality Control

CPC
DAS
19
9-89
2 **JUN 22 2017**

2 **17-06-22**

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

160879

Friday, May 05, 2017 9:09:08 AM

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 6/2/2017 **Start Qty:** 1.00 ***1***

Cust Item ID:

Required Date: 7/17/2017 **Req'd Qty:** 1.00 ***1***

Customer:

Reference: SCHEDULED/U

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

120 Identify as per dwg & Stock Location:

0.00

120

Memo

0.01

Packaging

Packaging

DAS

JUN 23 2017

130 QC21- Final Inspection - Work Order Release

0.00

130

Memo

0.10

OC

Quality Control

JUN 23 2017



DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

Picklist Print

Friday, May 05, 2017 9:09:05 AM

Page 1

Work Order ID: 160879

160879

Parent Item: PB67-43001-03

PB67-43001-03

Parent Item Name: Aft Blade Fold Assembly

Start Date: 6/2/2017

Required Date: 7/17/2017

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 08-07-30 new issue DD verified by:ec
 IPP Rev:B 08-12-04 up date part list DD Verified by:ec IPP Rev
 C 10.09.24 as per Rev C dwg EC verified by:DD IPP Rev:D 10.10.21
 added NAS1149F0532P DD verf:JLM IPP REV:E 16.11.21 DWG
 REV.D DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
240-107		Purchased	No			100	Each	90.0000	12	1224	DAS		JUN 15 2017
240-107									**				
SPRING SLOTTED PIN													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST579		90							
				m132006		1							
				m134651		89							
30345T21		Purchased	No			100	Each	28.0000	1	1224	DAS		JUN 15 2017
30345T21									**				
LANYARD													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST581		28							
				M135014		10							
				M135998		18							
30345T24		Purchased	No			100	Each	1.0000	3	2	DAS		JUN 15 2017
30345T24									**				
LANYARDS													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST581		1							
				m135525		1							

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QS1042) Approval	
Description Work Order Deviation		Disposition		Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
		OTHER : ☐			

Picklist Print

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Page 2

Work Order ID: 160879

Parent Item: PB67-43001-03

Parent Item Name: Aft Blade Fold Assembly

160879

PB67-43001-03

Start Date: 6/2/2017

Required Date: 7/17/2017

Start Qty: 1.00

Required Qty: 1.00 JUN 15 2017

3408A98 Purchased No 100 Each 31.0000 1 ****** **12** DAS **6** 9-89
3408A98
 DETENT BALL SPRING PLUNG

Location Loc Qty Loc Code

ST582 31
 123478 31

AN4-10A Purchased No 100 Each 162.0000 2 ****** **24** DAS **6** 9-89
AN4-10A
 Bolt

Location Loc Qty Loc Code

over003 125
 M137412 125
 ST345 37
 M134762 37

AN4-13A Purchased No 100 Each 522.0000 1 ****** **12** DAS **6** 9-89
AN4-13A
 Bolt

Location Loc Qty Loc Code

FG 20
 122808 20
 GA 70
 m134634 19
 m135470 51
 over003 200
 m137371 200
 Return2017 8
 m135470 8
 ST344 224
 m137321 224

137544

JUN 15 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

Picklist Print

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Page 3

Work Order ID: 160879

160879

Parent Item: PB67-43001-03

PB67-43001-03

Parent Item Name: Aft Blade Fold Assembly

Start Date: 6/2/2017

Required Date: 7/17/2017

Start Qty: 1.00

Required Qty: 1.00

AN4-15A Purchased No

100 Each 190.0000 4

AN4-15A

Bolt

**

DAS

6

9-89

JUN 15 2017

Location Loc Qty Loc Code

GA 10

120449 10

ST343 180

m108868 24

m132317 8

m137280 148

AN5-26A Purchased No

100 Each 28.0000 1

AN5-26A

Bolt

**

DAS

6

9-89

JUN 15 2017

Location Loc Qty Loc Code

ST337 28

111424 28

AN6-11A Purchased No

100 Each 4.0000 2

AN6-11A

BOLT

**

DAS

6

9-89

JUN 15 2017

Location Loc Qty Loc Code

ST335 4

M132576 4

AN6-16A Purchased No

100 Each 1.0000 2

AN6-16A

BOLT

**

DAS

6

9-89

JUN 15 2017

Location Loc Qty Loc Code

ST334 1

m132576 1

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Shop Packet Print

Page 3

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐							
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval				
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval			
Root Cause		FAULT CATEGORY									
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence	☐
Past Expiry Date	☐	Manufacturing Process	☐	OTHER :							
Misidentified	☐	Past Due	☐								

Picklist Print

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Page 4

Work Order ID: 160879

160879

Parent Item: PB67-43001-03

PB67-43001-03

Parent Item Name: Aft Blade Fold Assembly

Start Date: 6/2/2017

Required Date: 7/17/2017

Start Qty: 1.00

Required Qty: 1.00

AN8-13A
Bolt
Purchased No

100 Each 7.0000 2

DAS
6
9-89

AN8-13A

**

JUN 15 2017

Location

Loc Qty

Loc Code

ST332

7

M135945

7

BSP43
RIVET
Purchased No

100 Each 4.0000 3

DAS
6
9-89

BSP43

**

JUN 15 2017

Location

Loc Qty

Loc Code

ST557

4

M132703

4

CR3213-4-05
RIVET
Purchased No

100 Each 0.0000 1

DAS
6
9-89

CR3213-4-05

**

JUN 15 2017

D3440-1
Tube Guide (Supersedes B67-43001-25/-307)
Manufactured No

100 Each 2.0000 1

DAS
19
9-89

D3440-1

**

JUN 22 2017

Location

Loc Qty

Loc Code

Mezz2

2

142150

2

D3440-3
Clamp (Supersedes B67-43001-309)
Manufactured No

100 Each 2.0000 1

DAS
19
9-89

D3440-3

**

JUN 22 2017

Location

Loc Qty

Loc Code

Mezz2

2

142151

2

D3444-1
Velcro Loop Belt
Manufactured No

100 Each 0.0000 1

DAS
19
9-89

D3444-1

**

JUN 22 2017

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Shop Packet Print

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DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

Picklist Print

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Work Order ID: 160879

160879

Parent Item: PB67-43001-03

PB67-43001-03

Parent Item Name: Aft Blade Fold Assembly

Start Date: 6/2/2017

Required Date: 7/17/2017

Start Qty: 1.00

Required Qty: 1.00

D3447-9	Manufactured	No	100	Each	8.0000	2	24	DAS 19 9-89
D3447-9								
Swing Arm								
								JUN 2 2 2017

					<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>	
D3449-1	Manufactured	No	100	Each	2.0000	1	4	DAS 19 9-89
D3449-1								
Pad								
								JUN 2 2 2017

					<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>	
D3451-043	Manufactured	No	100	Each	0.0000	1	2	DAS 19 9-89
D3451-043								
Handle And Lock-Down Assembly								
								JUN 2 2 2017

D3451-045	Manufactured	No	100	Each	0.0000	1	2	DAS 19 9-89
D3451-045								
Handle And Lock-Down Assembly								
								JUN 2 2 2017

D3922-1	Manufactured	No	100	Each	16.0000	1	2	DAS 6 9-89
D3922-1								
Clip								
								JUN 1 5 2017

	<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST057		16	
	111733	2	
	148014	14	

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date: _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

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Work Order ID: 160879

160879

Parent Item: PB67-43001-03

PR67-43001-03

Parent Item Name: Aft Blade Fold Assembly

Start Date: 6/2/2017

Required Date: 7/17/2017

Start Qty: 1.00

Required Qty: 1.00

MS17984-C410

Purchased

No

100

Each

16.0000

1

DAS

MS17984-C410

QUICK PIN REPLACEMENT

**

6

JUN 15 2017

Location

Loc Qty

Loc Code

ST315

16

m137164

10

m137361

6

MS17984-C418

Purchased

No

100

Each

10.0000

3

DAS

MS17984-C418

QUICK RELEASE PIN

**

6

JUN 15 2017

Location

Loc Qty

Loc Code

FG

1

123482

1

ST315

9

152031

1

m137412

8

MS21042L4

Purchased

No

100

Each

3,109.000

9

DAS

MS21042L4

Nut

**

6

JUN 15 2017

Location

Loc Qty

Loc Code

FP001

10

m133363

10

GA

148

m135058

148

OVER007

1400

m137371

1000

m137402

400

ST303

1551

m136986

3

m137166

12

m137321

1536

Friday, May 05, 2017 9:09:06 AM

Shop Packet Print

Page 6

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐							
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval				
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval			
Root Cause		FAULT CATEGORY									
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence	☐
Past Expiry Date	☐	Manufacturing Process	☐	OTHER :							
Misidentified	☐	Past Due	☐								

Picklist Print

Page 7

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Work Order ID: 160879

160879

Parent Item: PB67-43001-03

PB67-43001-03

Parent Item Name: Aft Blade Fold Assembly

Start Date: 6/2/2017

Required Date: 7/17/2017

Start Qty: 1.00

Required Qty: 1.00

MS21042L5 Purchased No

100 Each 271.0000 1 **+2**

MS21042L5

DAS

Nut

6
9-89

Location	Loc Qty	Loc Code
GA	16	
m127813	16	
ST303	255	
m136986	1	
m137075	75	
m137164	29	
m137361	150	

137478

JUN 15 2017

MS21042L6 Purchased No

100 Each 205.0000 4

MS21042L6

DAS
6
9-89

Nut

Location	Loc Qty	Loc Code
OVER007	100	
m137361	100	
ST303	50	
m137075	50	
ST313	55	
m136740	5	
m136986	50	

Q

JUN 15 2017

MS24694-S100 Purchased No

100 Each 60.0000 2

MS24694-S100

DAS
6
9-89

Flat Head Screw

Location	Loc Qty	Loc Code
ST283	60	
m135864	60	

2

JUN 15 2017

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Shop Packet Print

Page 7

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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				Completed By																	
				Lead hand / Supervisor Approval Verification																	
				QC / QA Coordinator Approval																	
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OTHER : ☐																					

Picklist Print

Friday, May 05, 2017 9:09:06 AM

Work Order ID: 160879

160879

Parent Item: PB67-43001-03

PR67-43001-03

Parent Item Name: Aft Blade Fold Assembly

Start Date: 6/2/2017

Required Date: 7/17/2017

Start Qty: 1.00

Required Qty: 1.00

MS27039-1-07

Purchased

No

100

Each

66.0000

1

MS27039-1-07

Screw

**

DAS

6
9-89

JUN 15 2017

Location

Loc Qty

Loc Code

GA

48

m137320

48

ST281

18

m135948

18

MS27039-1-18

Purchased

No

100

Each

1,624.000

1

MS27039-1-18

Screw

**

DAS

6
9-89

JUN 15 2017

Location

Loc Qty

Loc Code

GA

239

123522

39

124326

200

over006

1200

124326

1200

ST280

185

124326

185

MS51859-6

Purchased

No

100

Each

12.0000

8

MS51859-6

WASHER

**

DAS

6
9-89

JUN 15 2017

Location

Loc Qty

Loc Code

st268

12

m134502

12

MS51859-7

Purchased

No

100

Each

83.0000

2

MS51859-7

Washer

**

DAS

6
9-89

JUN 15 2017

Location

Loc Qty

Loc Code

st268

83

M135058

83

Friday, May 05, 2017 9:09:06 AM

Shop Packet Print

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coor. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coor. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																															
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		OTHER : ☐																																																																					

Picklist Print

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Work Order ID: 160879

160879

Parent Item: PB67-43001-03

PR67-43001-03

Parent Item Name: Aft Blade Fold Assembly

Start Date: 6/2/2017

Required Date: 7/17/2017

Start Qty: 1.00

Required Qty: 1.00

MS51859-8 Purchased No

100

Each

201.0000

8

**

816

DAS

6

9-89

JUN 15 2017

MS51859-8

Washer

Location

Loc Qty

Loc Code

st268

201

m134606

201

NAS1149DN632J

Purchased

No

100

Each

271.0000

4

**

916

DAS

6

9-89

JUN 15 2017

NAS1149DN632J

Washer

Location

Loc Qty

Loc Code

ST265

271

m134370

271

NAS1149F0316P

Purchased

No

100

Each

84.0000

1

**

8

DAS

6

9-89

JUN 15 2017

NAS1149F0316P

WASHER

Location

Loc Qty

Loc Code

ST262

84

M132579

84

NAS1149F0432P

Purchased

No

100

Each

2,417.000

16

**

2

1632

DAS

6

9-89

JUN 15 2017

NAS1149F0432P

WASHER

Location

Loc Qty

Loc Code

ST260a

2000

M137361

1000

M137412

1000

ST262

417

M136442

417

1632

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Shop Packet Print

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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval	
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐			
Design ☐	☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐			
Doc/Data ☐	☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐			
Equip/Tooling ☐	☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐			
Handling/Pre ☐	☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐			
Material ☐	☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐			
Internal Transport ☐	☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐			
Tribal Knowledge ☐	☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐			
LOA ☐	☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐			
Substation ☐	☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐			
Past Expiry Date ☐	☐	Manufacturing Process ☐	OTHER : _____						
Misidentified ☐	☐	Past Due ☐							

Picklist Print

Friday, May 05, 2017 9:09:07 AM

Work Order ID: 160879

160879

Parent Item: PB67-43001-03

PR67-43001-03

Parent Item Name: Aft Blade Fold Assembly

Start Date: 6/2/2017

Required Date: 7/17/2017

Start Qty: 1.00

Required Qty: 1.00

NAS1149F0532P Purchased No

100 Each 1,601.000 2

NAS1149F0532P

Washer

**

DAS
6
9-89

Location Loc Qty Loc Code

ST260a 600

m133725 600

ST262 1001

18057 1001

NAS1149F0632P Purchased No

100 Each 96.0000 8

NAS1149F0632P

WASHER

**

DAS
6
9-89

Location Loc Qty Loc Code

ST262 96

m134497 96

NAS1149F0832P Purchased No

100 Each 84.0000 2

NAS1149F0832P

WASHER

**

DAS
6
9-89

Location Loc Qty Loc Code

ST262 84

18057 84

NAS43DD3-61 Purchased No

100 Each 8.0000 1

NAS43DD3-61

Spacer

**

DAS
6
9-89

Location Loc Qty Loc Code

ST550 8

m128635 8

PB67-43001-09 Manufactured No

100 Each 0.0000 1

PR67-43001-09

Aft Blade Fold Assembly Weldment

**

DAS
19
9-89

160912

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐			
Design ☐	☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐			
Doc/Data ☐	☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐			
Equip/Tooling ☐	☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐			
Handling/Pre ☐	☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐			
Material ☐	☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐			
Internal Transport ☐	☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐			
Tribal Knowledge ☐	☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐			
LOA ☐	☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐			
Substation ☐	☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐			
Past Expiry Date ☐	☐	Manufacturing Process ☐	OTHER :						
Misidentified ☐	☐	Past Due ☐							

Picklist Print

Page 11

Friday, May 05, 2017 9:09:07 AM

Work Order ID: 160879

160879

Parent Item: PB67-43001-03

PR67-43001-03

Parent Item Name: Aft Blade Fold Assembly

Start Date: 6/2/2017

Required Date: 7/17/2017

Start Qty: 1.00

Required Qty: 1.00

PB67-43001-13 Manufactured No

not pulled
160910

PR67-43001-13

Aft Adjustable Blade Support Assembly

PB67-43001-135 Manufactured No

PR67-43001-135

Male Eye

Location

Loc Qty

Loc Code

Mezz2

2

139212

2

PB67-43001-137 Manufactured No

PR67-43001-137

Locking Sleeve

Location

Loc Qty

Loc Code

Mezz2

1

139213

1

PB67-43001-155 Manufactured No

PR67-43001-155

Pin

Location

Loc Qty

Loc Code

Mezz2

11

142807

11

PB67-43001-17 Manufactured No

PR67-43001-17

Aft Adjustable Blade Support Assembly

PB67-43001-21 Manufactured No

PR67-43001-21

Upper Blade Support And Cover Assembly

PB67-43001-23 Manufactured No

PR67-43001-23

Lower Blade Support And Cover Assembly

Location

Loc Qty

Loc Code

Mezz2

11

160903

11

Friday, May 05, 2017 9:09:07 AM

Shop Packet Print

Page 11

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date: _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition					
								Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
OTHER : _____									

Picklist Print

Page 12

Friday, May 05, 2017 9:09:07 AM

Work Order ID: 160879

160879

Parent Item: PB67-43001-03

PR67-43001-03

Parent Item Name: Aft Blade Fold Assembly

Start Date: 6/2/2017

Required Date: 7/17/2017

Start Qty: 1.00

Required Qty: 1.00

PB67-43001-261

Manufactured

No

100

Each

1.0000

2 2

PR67-43001-261

Lever Arm

**

JUN 2 2 2017

DAS
19
9-89

Location

Loc Qty

Loc Code

Mezz2

160905
152090

1
1

(4)

PB67-43001-265

Manufactured

No

100

Each

4.0000

5 5

PR67-43001-265

Deltin Bushing

**

JUN 2 2 2017

DAS
19
9-89

Location

Loc Qty

Loc Code

Mezz2

160921
152110

4
4

(10)

PB67-43001-299

Manufactured

No

100

Each

1.0000

2 2

PR67-43001-299

Bushing

**

JUN 2 2 2017

DAS
19
9-89

Location

Loc Qty

Loc Code

Mezz2

160814
139216

1
1

(4)

PB67-43001-305

Manufactured

No

100

Each

3.0000

1 1

PR67-43001-305

Bearing

**

JUN 2 2 2017

DAS
19
9-89

Location

Loc Qty

Loc Code

Mezz2

148793
160901

3
3

(2)

PB67-43001-37

Manufactured

No

100

Each

0.0000

1 1

PR67-43001-37

Tube Arm Assembly

(2) **

JUN 2 2 2017

DAS
19
9-89

PB67-43001-57

Manufactured

No

100

Each

0.0000

1 1

PR67-43001-57

Stabilizer Arm

**

JUN 2 2 2017

DAS
19
9-89

Friday, May 05, 2017 9:09:07 AM

Shop Packet Print

Page 12

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No.: _____ NCR No.: _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date: _____	Step #: _____	QTY Effective: _____		MRB (QS1042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

Picklist Print

Page 13

Friday, May 05, 2017 9:09:07 AM

Work Order ID: 160879

160879

Parent Item: PB67-43001-03

PR67-43001-03

Parent Item Name: Aft Blade Fold Assembly

Start Date: 6/2/2017

Required Date: 7/17/2017

Start Qty: 1.00

Required Qty: 1.00

PB67-43001-59

Manufactured No

100

Each

1.0000

1 1

PR67-43001-59

Adjustable Attachment Arm

JUN 22 2017

DAS
19
9-89

Location

160918

Loc Qty

Mezz2

153617

1

1

Loc Code

2

PB67-43001-63

Manufactured No

100

Each

0.0000

1 1

PR67-43001-63

Handle Assembly

JUN 22 2017

DAS
19
9-89

160909

2

Friday, May 05, 2017 9:09:07 AM

Shop Packet Print

Page 13

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

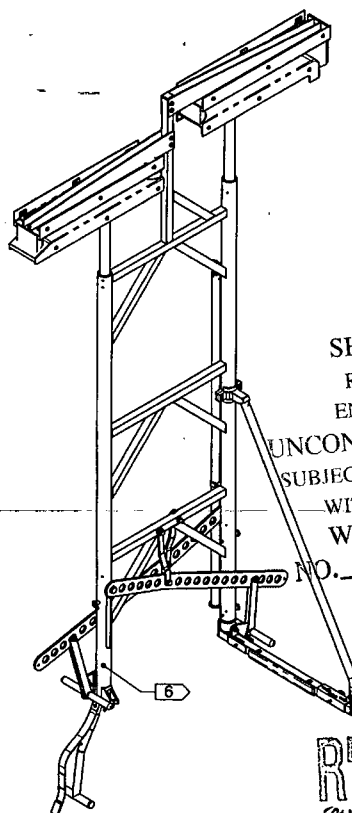
QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date: _____		Step #: _____		QTY Effective: _____			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER: _____							
Misidentified ☐	Past Due ☐								

ITEM	QTY -03	P/N	DESCRIPTION
	X	B67-43001-03	AFT BLADE FOLD ASSY
1	1	B67-43001-09	AFT BLADE FOLD ASSY WELDMENT
2	1	B67-43001-13	AFT ADJUSTABLE BLADE SUPPORT ASSY
3	1	B67-43001-17	AFT ADJUSTABLE BLADE SUPPORT ASSY
4	1	B67-43001-21	UPPER BLADE SUPPORT AND COVER ASSY
5	1	B67-43001-23	LOWER BLADE SUPPORT AND COVER ASSY
6	1	B67-43001-37	TUBE ARM ASSEMBLY
7	1	B67-43001-57	STABILIZER ARM
8	1	B67-43001-59	ADJUSTABLE ATTACHMENT ARM
9	1	B67-43001-63	SHORT T-HANDLE ASSEMBLY
10	1	B67-43001-135	MALE EYE
11	1	B67-43001-137	LOCKING SLEEVE
12	1	B67-43001-155	PIN
13	2	B67-43001-261	LEVER ARM
14	5	B67-43001-265	DELRIIN BUSHING
15	2	B67-43001-299	BUSHING
16	1	B67-43001-305	BEARING
17	1	D3440-1	TUBE GUIDE
18	1	D3440-3	CLAMP
19	1	D3444-1	VELCRO LOOP BELT
20	2	D3447-9	SWING ARM
21	1	D3449-1	PAD
22	1	D3451-043	HANDLE & LOCK-DOWN ASSY
23	1	D3451-045	HANDLE & LOCK-DOWN ASSY
24	1	D3922-1	CLIP
25	1	30345T21	LANYARD
26	3	30345T24	LANYARD
27	1	3408A98	DETENT BALL PLUNGER
28	2	AN4-10A	BOLT
29	1	AN4-13A	BOLT
30	4	AN4-15A	BOLT
31	1	AN5-26A	BOLT
32	2	AN6-11A	BOLT, MACHINE
33	2	AN6-16A	BOLT, MACHINE
34	2	AN8-13A	BOLT, MACHINE
35	3	BSP43	RIVET
36	1	CR3213-4-05	RIVET
37	12	MS171534	SPRING SLOTTED TENSION PIN (OR 240-107)
38	1	MS17984-C410	PIN, QUICK RELEASE
39	3	MS17984-C418	PIN, QUICK RELEASE
40	9	MS21042L4	NUT, SELF-LOCKING
41	1	MS21042L5	NUT, SELF-LOCKING
42	4	MS21042L6	NUT, SELF-LOCKING
43	2	MS24694-S100	SCREW, CSK 100*
44	1	MS27039-1-07	SCREW, PAN-HEAD
45	1	MS27039-1-18	SCREW, PAN-HEAD
46	8	MS51859-6	WASHER
47	2	MS51859-7	WASHER
48	8	MS51859-8	WASHER
49	4	NAS1149DN632J	WASHER

ITEM	QTY -03	P/N	DESCRIPTION
	X	B67-43001-03	AFT BLADE FOLD ASSY
50	1	NAS43DD3-61	SPACER
51	1	NAS1149F0316P	WASHER
52	16	NAS1149F0432P	WASHER
53	2	NAS1149F0532P	WASHER
54	8	NAS1149F0632P	WASHER
55	2	NAS1149F0832P	WASHER



B67-43001-03 AFT BLADE FOLD ASSY

NOTES:

- 1) MATERIAL: NONE
- 2) FINISH: TOUCH UP PAINT WITH SANDFLEX GREEN.
POSSIBLE SUPPLIER BERTRAND BODY SHOP SUPPLIES
P/N DART01K
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH RED LABEL
- 7) WEIGHT: 54.57 lbs
- 8) WITH THE INNER TUBE CRADLE ASSEMBLY LOCKED IN ITS LOWEST MOST RECESSED POSITION, TRANSFER DRILL $\varnothing 0.250$ DIA HOLE FROM THE OUTER TUBE TO THE INNER TUBE AND THRU THE OUTER TUBE. DEBURR, REMOVE DEBRIS, AND TOUCH UP PAINT PER ITEM 2 AS REQUIRED. 2 PL.
- 9) INSTALL TEFLON BUSHING -265 INSIDE THE OUTER TUBE. MATCH DRILL BUSHING TO EXISTING HOLES IN OUTER TUBE USING $1/8"$ DIAMETER DRILL. INSERT MS171534 (OR 240-107) SPRING SLOTTED PIN AND GRIND FLUSH WITH CONTOUR OF OUTER TUBE.
10 PL (2 PL PER BUSHING)
- 10) DRILL $\varnothing 0.250$ DIA HOLE THRU -09/-285/-305 WITH -37 AT VERTICAL FULL OPEN POSITION. DRILL ADDITIONAL HOLE WITH -37 AT FULL CLOSED POSITION, ASSURING -37 CLEARS ADJACENT STRUCTURE.
- 12) DRILL A $\varnothing 0.128$ DIA HOLE THRU -343 (COMPONENT OF -37) AND -25 (COMPONENT OF -09 ASSY). INSERT MS171534 (OR 240-107) SPRING SLOTTED PIN, AND GRIND FLUSH WITH -37.
- 13) INSERT -135 INTO -243 TUBE (COMPONENT OF -09 ASSY) ALIGN HOLES, ASSURING ORIENTATION SHOWN. INSERT 3408A98 DETENT BALL, ASSURING BALL PROTRUDES SLIGHTLY ABOVE OUTER SURFACE OF -243 TUBE. LOCATE AND INSTALL AN MS171534 (OR 240-107) SPRING SLOTTED PIN BY DRILLING A $\varnothing 0.128$ DIA HOLE THRU -243 AND -135. ENSURE -137 SLEEVE SLIDES FREELY OVER HINGE AND LOCKS INTO DETENT.
- 14) BOND D3449-1 TO B67-43001-09 USING CONTACT CEMENT AS PER MANUFACTURER'S SPECIFICATION.
- 15) INSERT MS171534 (OR 240-107) SPRING SLOTTED PIN AND GRIND FLUSH WITH CONTOUR OF OUTER TUBE.

SHOP COPY
RETURN TO
ENGINEERING

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 160879 MJS
170505

RELEASED
2016-11-09
EEN 16-655

APPROVED

D	MS24694-S100 WAS MS24694-S109, MS17984-C410 WAS MS17984-C408, MS27039-1-18 WAS MS27039-1-23, QTY (12) MS171534 WAS QTY(8), ADDED NOTE 15, GENERAL UPDATE OF BOM, CORRECT TYPOGRAPHICAL ERROR IN NOTES 240-107 WAS 240107, REASON PAR15-437	SAD	16.10.28
C	REDRAWN PREMIER AVIATION DRAWING (AW DART QSI 018 AND QSI 043, FOR PREVIOUS REVISIONS, REFER TO SHEET 3 OF PREMIER AVIATION DRAWING No. B67-43001. REASON: SEE PAR09-011	VS	10.06.14
REV.	DESCRIPTION	BY	DATE
DESIGN	RW		
DRAWN	SAD		
CHECKED	MB		
MFG. APPR.	DD		
APPROVED	WM (M)		
DE APPR.	N/A		
DATE	16.10.28		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

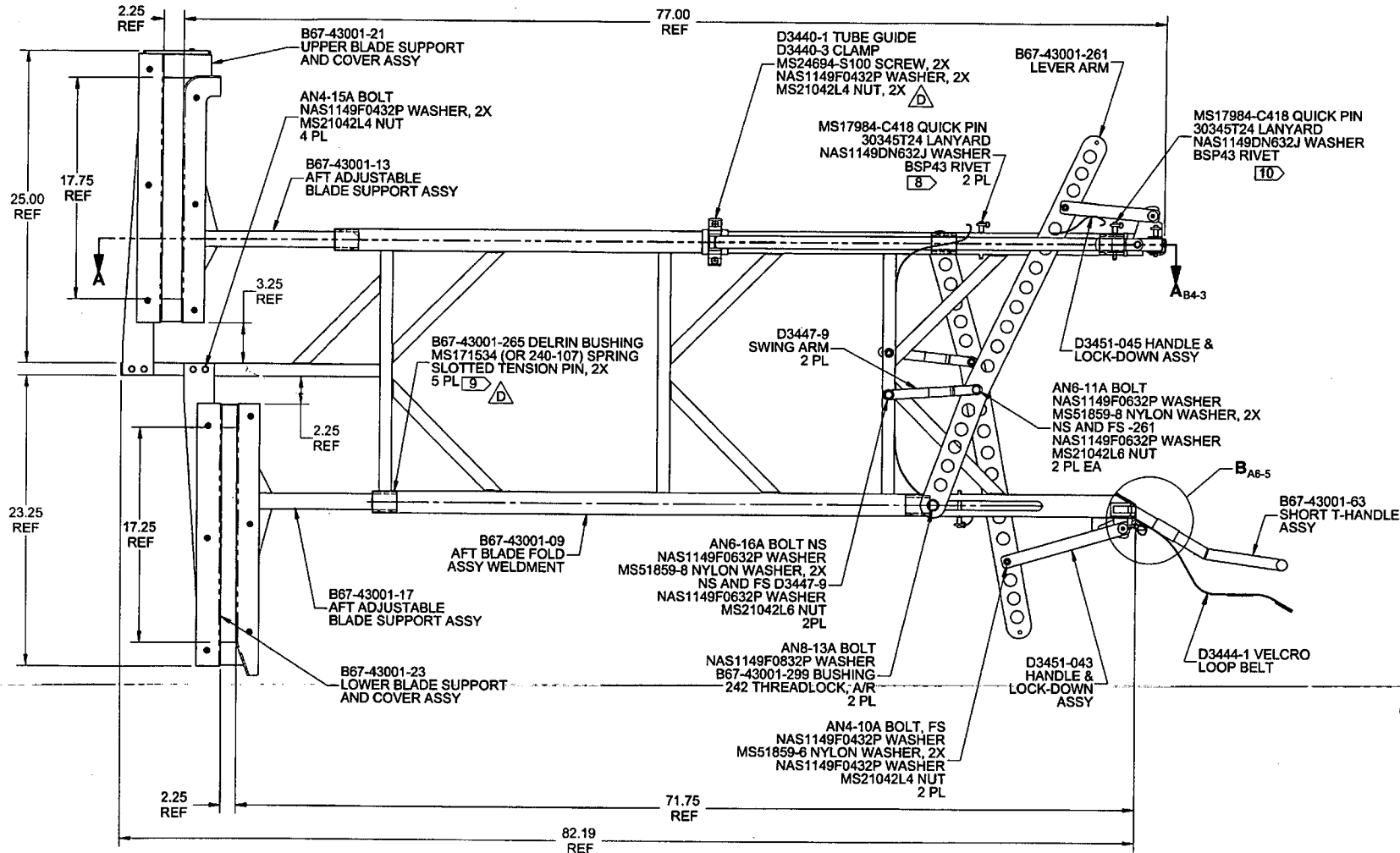
DRAWING NO.
B67-43001-03

REV. D
SHEET 1 OF 5

TITLE
AFT BLADE FOLD ASSY

SCALE
NTS

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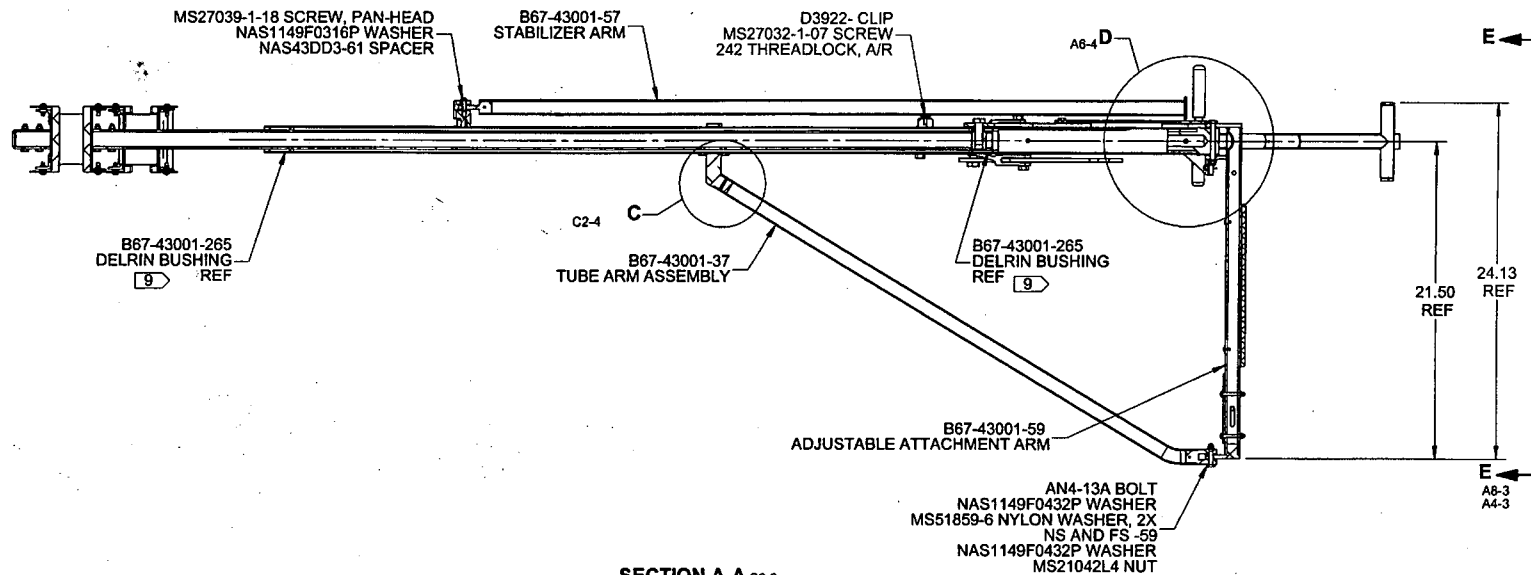


B67-43001-03 AFT BLADE FOLD ASSY

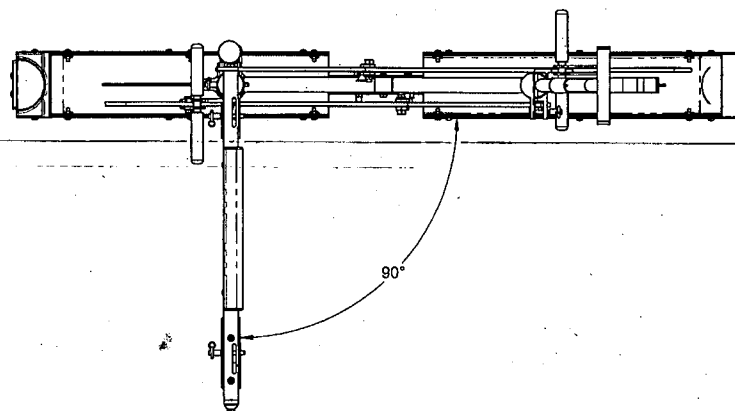
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2016-11-09

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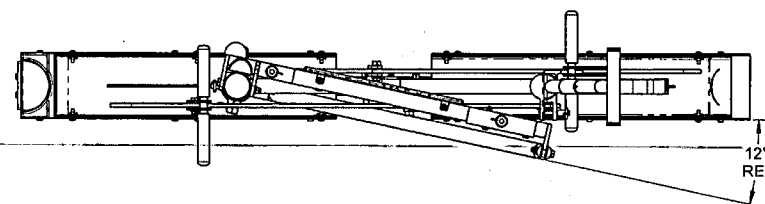
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DRAWN	SAD	HAWKESBURY, ONTARIO, CANADA	
CHECKED	MB	DRAWING NO.	REV. D
MFG. APPR.	DD	B67-43001-03	SHEET 2 OF 5
APPROVED	WM	TITLE	SCALE
DE APPR.	N/A	AFT BLADE FOLD ASSY	NTS
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SECTION A-A C2-2



C1-3 VIEW E-E: VERTICAL FULL OPEN OR "IN USE" POSITION [10]



C1-3 VIEW E-E: FULL CLOSED OR "STORAGE" POSITION [10]

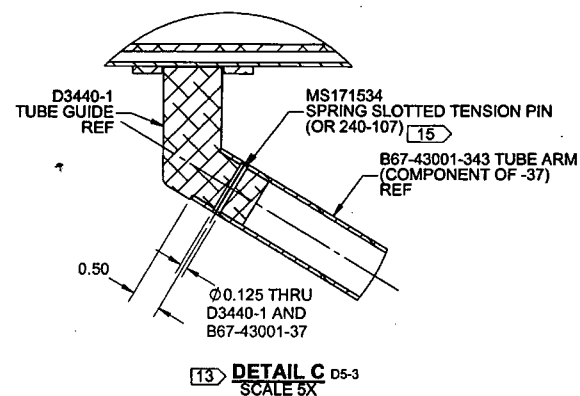
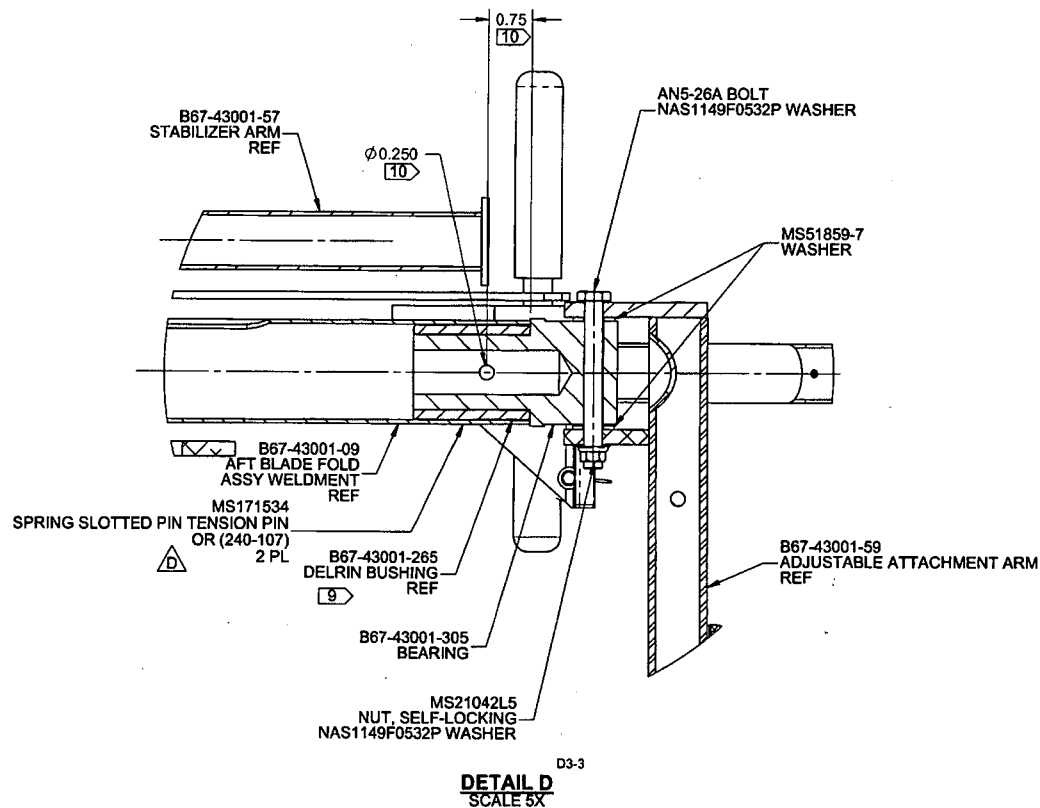
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8 7 6 5 4 3 2 1



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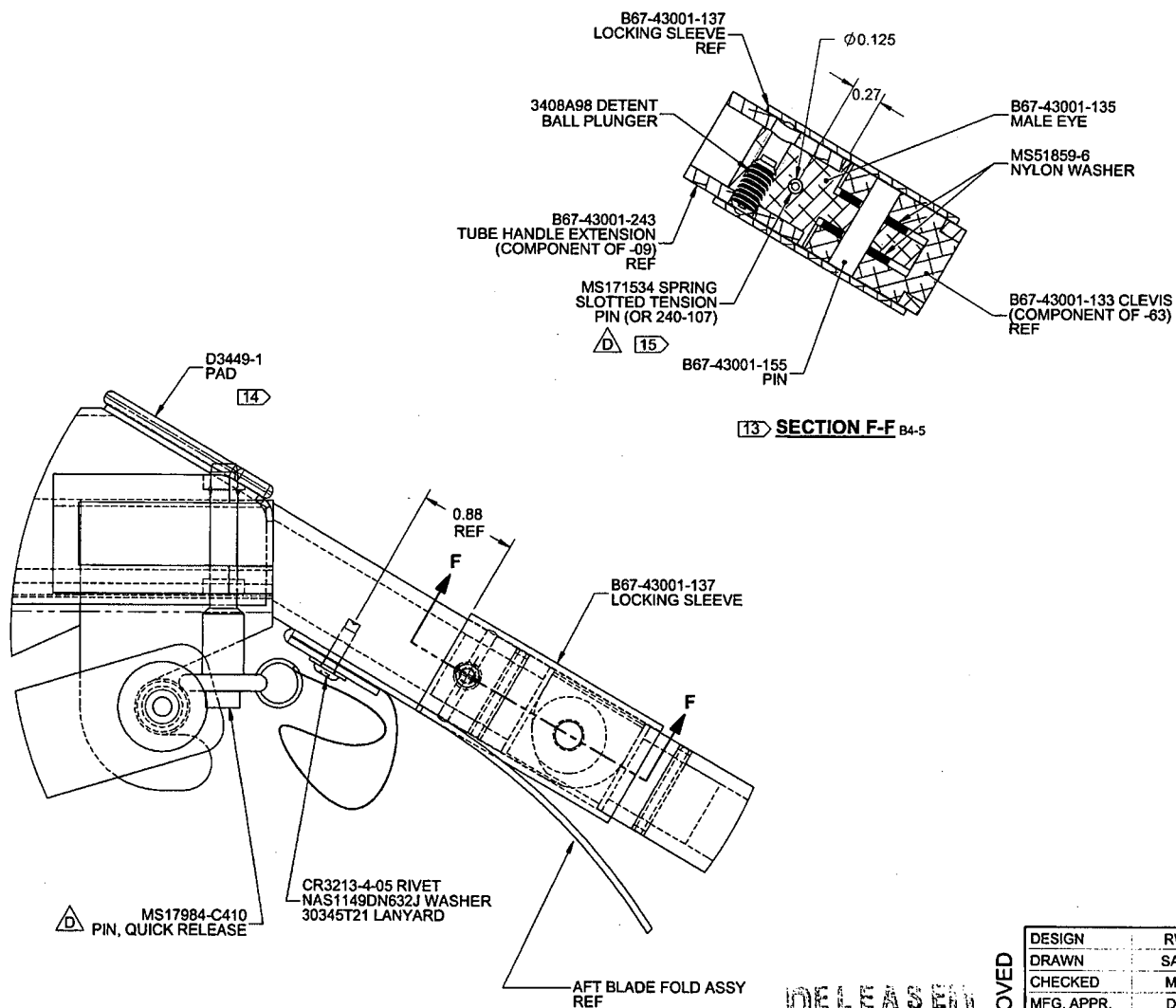
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